

Work Order ID 53459

November 9, 2009 10:13:37 AM



Page 1

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 05/11/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Handwritten signature and date 09.11.08

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3178	Rev A

105 0.00



Waterjet Memo

FLOW CNC Waterjet

Handwritten: 6061, .062

Handwritten: A, A

Handwritten: 139-11-18

Handwritten: 7 in a circle

120 0.00



QC QC2- Inspect parts off machine FAI/FAIB Memo

Quality Control

Handwritten: 139-11-18

130 0.00



QC QC8- Inspect parts - second check Memo

Quality Control

Handwritten: 2) 802/11/19

Handwritten: 27 in a circle

Work Order ID 53459

November 9, 2009 10:13:37 AM



Page 2

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 05/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- C'sink D3178-1 holes as per Dwg D3178□2- Deburr

09/11/23 (7)

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

27 09/11/23

(X7) 0

160

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

27 09/11/24

(X7) 0

Work Order ID 53459



Page 3

November 9, 2009 10:13:37 AM

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 05/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>BL 09-11-24</i>		<i>(7)</i>				
180 Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3178	0.00 0.00							<i>09/11/26 (7)</i>
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>2) 09/11/26</i>		<i>(7) φ</i>				

Work Order ID 53459

Page 4

November 9, 2009 10:13:37 AM

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 05/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: 72

0.00



Packaging

Memo

0.00

Packaging

69/4/30 (7)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30 7Bl 09-11-30
(7)

Picklist Print

November 9, 2009 10:13:36 AM

Page 1

Work Order ID: 53459

Parent Item: D3178-041RevA

Parent Item Name: Nut Plate

Comments: IPP REV: B NOW ON WATERJET JLM VERIFIED BY:DD

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M5052H328.063		Purchased	No			180	sf	127.3237	0.1465	4000		
---------------	--	-----------	----	--	--	-----	----	----------	--------	------	--	--

5052-H32.063 Sheet

m6061 T65.063

This Batch only

SE Dug ATTACHED

MS20426AD3 3 06/11/26 Purchased No

RIVET

M7681

MS21059L3 Purchased No

Nut Plate

Warehouse

Location

Main Warehouse

MAT 110551

103755

107276

112442

Loc Qty

127.3237

1.3237

30

96

Loc Code

110551

Warehouse

Location

Main Warehouse

ST

104374

110398

Loc Qty

7861

3861

4000

Loc Code

Warehouse

Location

Main Warehouse

ST

109962

111925

Loc Qty

305

11

294

Loc Code

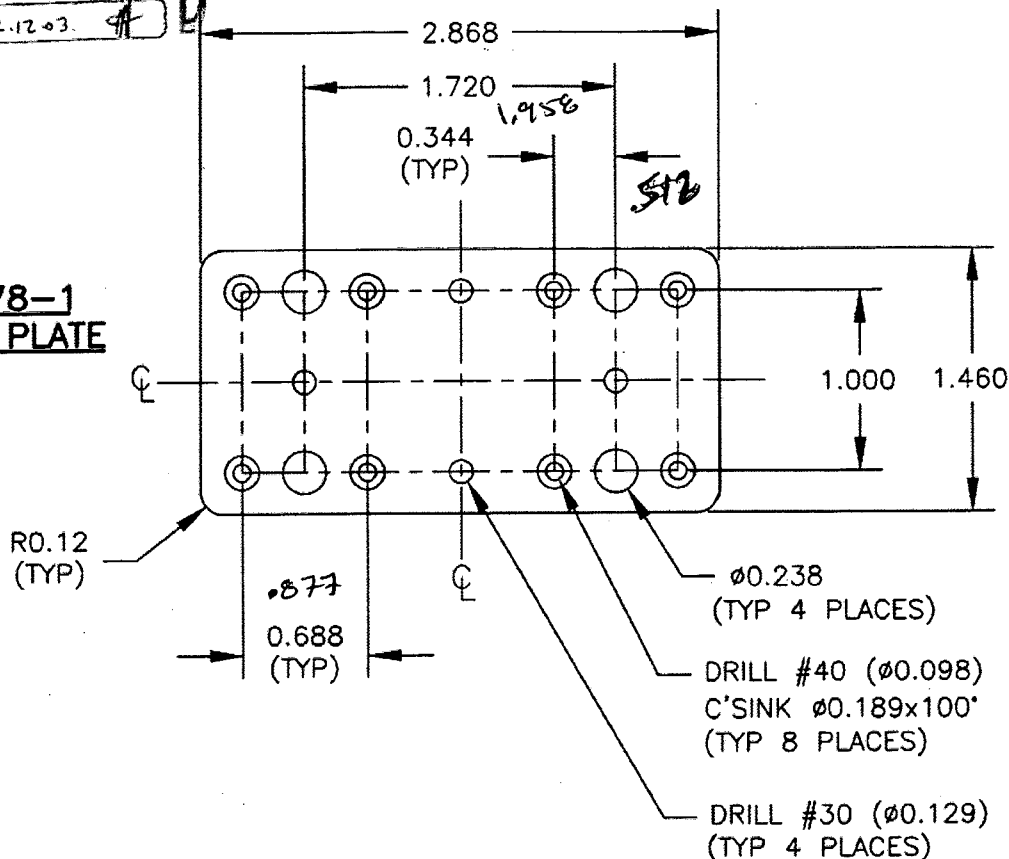
28



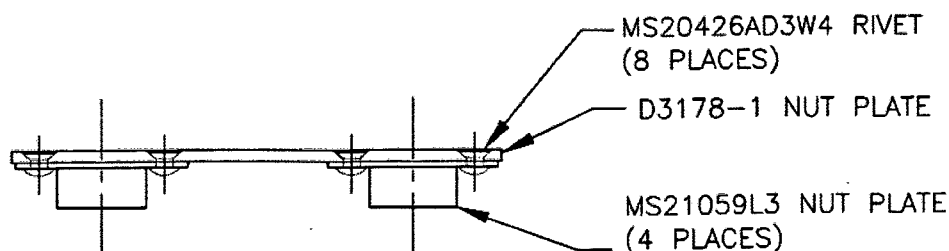
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

RELEASED
02-12-03

D3178-1
NUT PLATE



D3178-041
NUT PLATE



NOTES. D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8) (REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 534154

NO. 53459
09-11-5